

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

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May 02, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.08-000004

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

Status of the 114m Mock-Up

Due to the misalignment of skin plates of the two halves of the 114m mock-up during fit-up (11mm for skin plate B and the 10mm for of skin plate D), three-jacks were used align the skin plates prior to splice-plate bolting. The use of jacks to align the skin plates within 2mm, as provided for in Section 3.5.1.14 of AWS D1.5, was not included in your approved fabrication procedure. In addition, the use of jacks may have deformed the skin plates, and/or locked-in some residual stresses in either the skin plates or splice bolts.

Because the approved fabrication procedure (Submittal 94R1) has failed to demonstrate a complete procedure, or one that might not be repeatable in actual production, the mock-up procedure is considered unsatisfactory at this time. Please revise and resubmit the 114m mock-up Fabrication/Erection Procedure to include all steps to be used in fabrication. Also, please investigate what residual stresses remain in the skin plates and/or bolts as a result of the jacking used to correct the misalignment. Please include the jacking stresses that were used either by direct measurement with disassembly, or by theoretical calculation, i.e., finite element analysis and provide your findings to the Engineer for review. A new mock-up, or partial mock-up, may be required after approval of the new revised Fabrication/Erection procedure.

Based on discussions on Pier 7 at the working drawing campus, it is the Department's understanding that ABFJV will be performing a survey of the 114-meter mock-up, in order to validate the dimensional verification plan and obtain information about the overall distortion of the mock-up, and that these measurements will be provided to the Engineer for information only. It is further understood, that the information provided will not constitute an acceptance or rejection of either the mock-up or the dimensional verification plan (DVP). Please inform the Department if our understanding is incorrect.

American Bridge/Fluor Enterprises, a JV
May 02, 2008
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If you have questions, please call Douglas Coe @ (510) 714-7079.

Sincerely,

<<< ORIGINAL SIGNED >>>

GARY PURSELL
Resident Engineer

cc: Dave Williams, Gary Pursell, Rick Morrow, Jason Tom, Peter Siegenthaler, Scott Kennedy,
Mark Woods
file: 05.03.01